

Date: Thursday, 02/10/2008 10:34:32 AM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|-----------------------|---------------------------------------|--|------------------|-------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : STEP HI LONG | | |
| Job Number | : 42412 | | Part Number | : D32721 | | |
| Estimate Number | : 12897 | | Drawing Number | : D3272 REV B | | |
| P.O. Number | : | | Project Number | : N/A | | |
| This Issue | : 02/10/2008 S.O. No. : | | Drawing Revision | : B | | |
| Prsh Rev. | : NC | | Material | : | | |
| First Issue | : / / Type : LARGE FAB ASSY | | Due Date | : 30/10/2008 Qty: 20 Um: Each | | |
| Previous Run | : 42318 | | | | | |
| Written By | : | | | | | |
| Checked & Approved By | : <u>JULIE LECOCQ</u> | | | | | |
| Comment | : Est Rev:A New Issue 07-06-09 JLM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---|-----------------------|------------------------------|-----------------------------------|
| 1.0 | D2622120C | Step Extrusion | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) | | | |
| | Pick: | | |
| Qty Part Number Description Batch | | | |
| 1 | D2622-120 | Extrusion | <u>B42155</u> <u>SAD 08-11-27</u> |
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 | |
| Comment: LARGE FABRICATION RESOURCE 1 | | | |
| 1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A | | | |
| 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. | | | |
| 3-Deburr <u>SAD 08-11-27</u> <u>20</u> | | | |
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP | |
| Comment: INSPECT WORK TO CURRENT STEP | | | |
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 | |
| Comment: PACKAGING RESOURCE #1 | | | |
| Identify and Stock | | | |
| Location: <u>WA</u> | | | |
| <u>SAD 08-11-27</u> <u>20</u> | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 02/10/2008 10:34:32 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP HI LONG

Job Number: 42412

Part Number: D32721

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/02 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-12-02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|----------------------|----------------------|---|------------------------|
| DESIGN <i>QP</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CE</i> | APPROVED <i>H</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED07.06.04 *H*

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| 16 | 16 | MS20600AD4W4 | RIVET |

**GENERAL NOTES:**

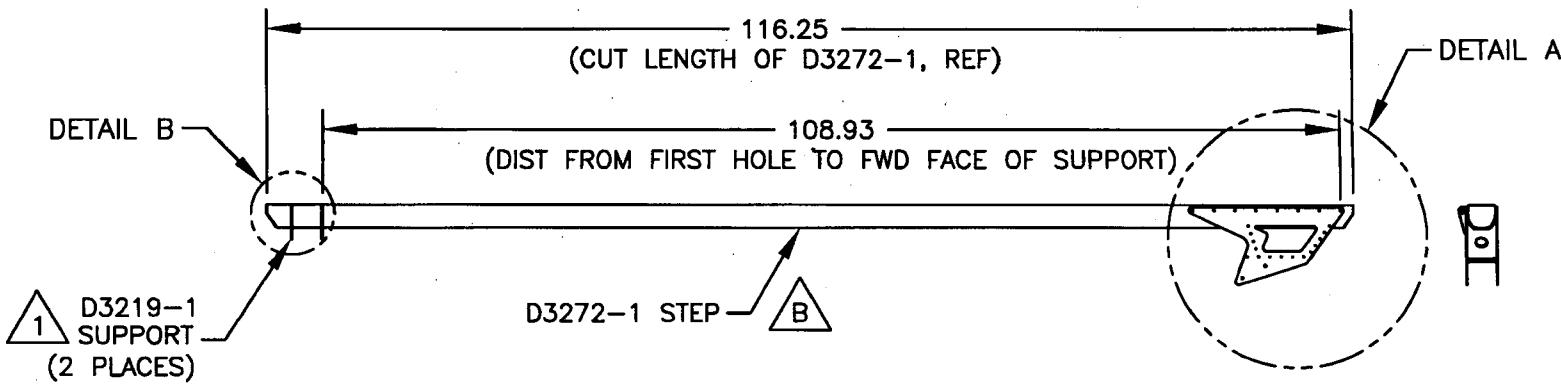
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *45912*

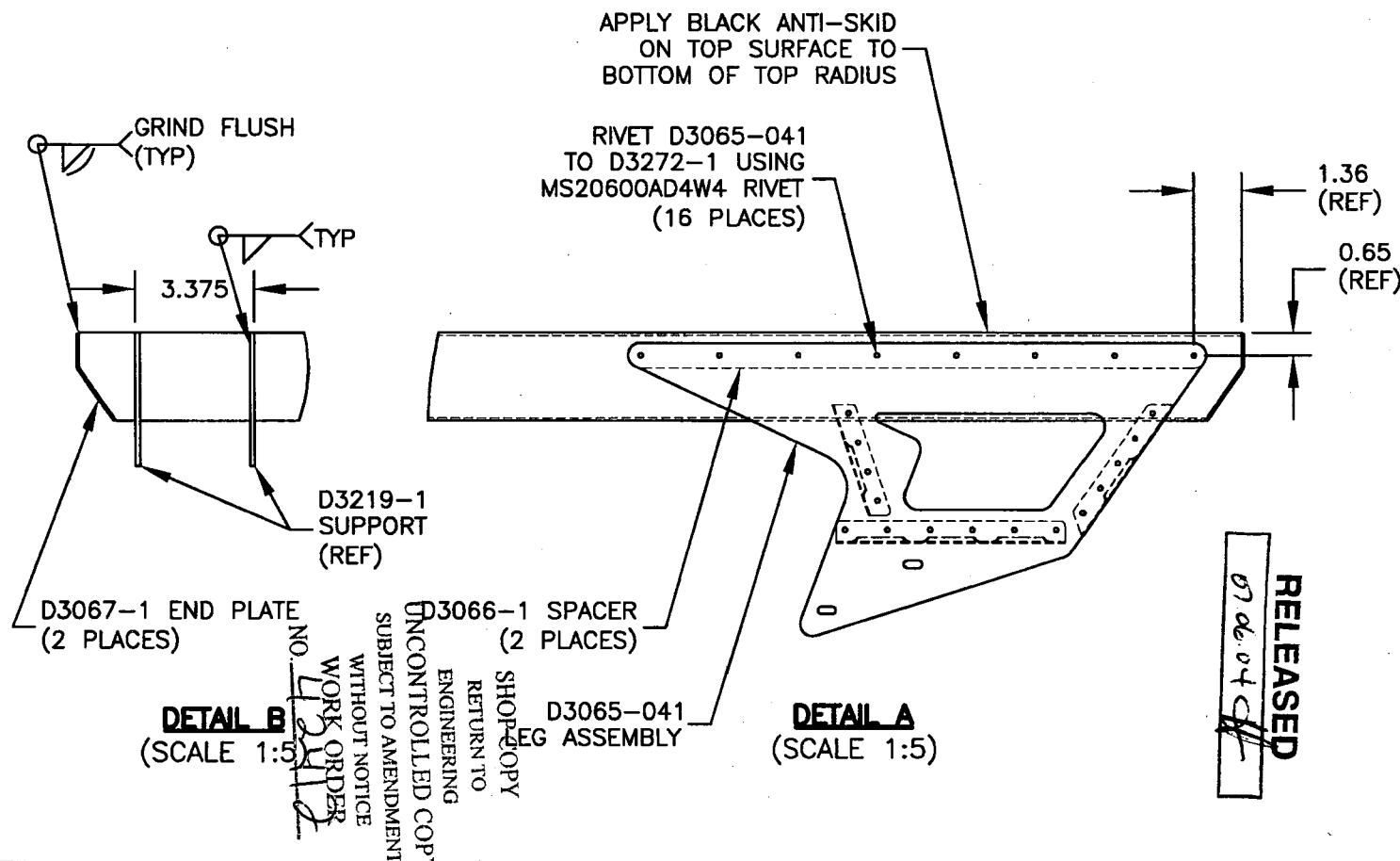
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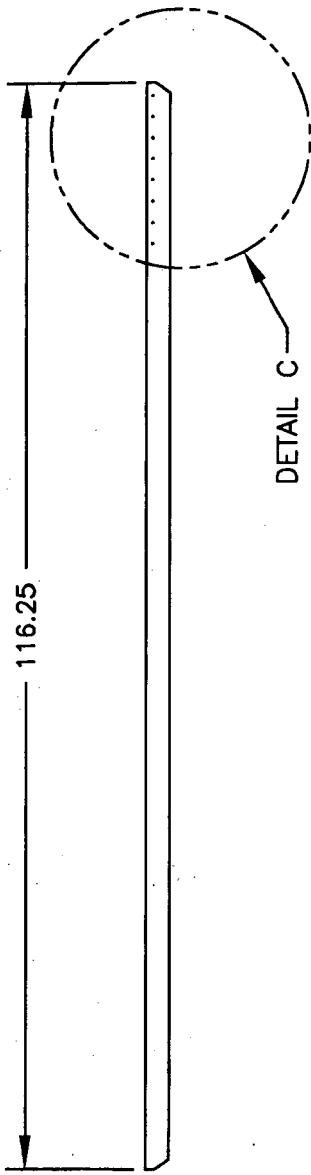
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



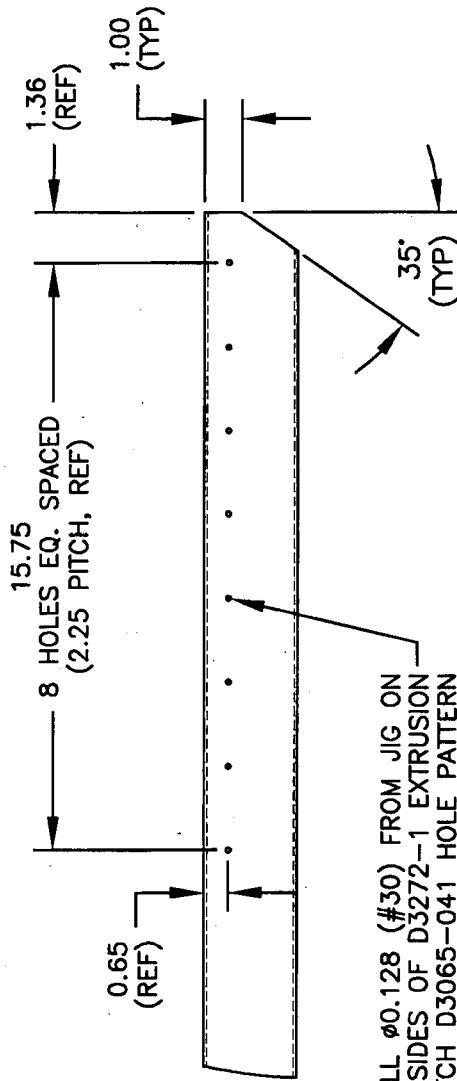
| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|----------|----------|-----------------------------|
| 97 | J.B. | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | REV. B |
| C.E. | | DRAWING NO. |
| 07.05.18 | | D3272 |
| | | SHEET 2 OF 3 |
| | | STEP ASSEMBLY, LH LONG |
| | | SCALE 1:20 |

DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>QP</i> | DRAWN BY <i>BS</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CE</i> | APPROVED <i>CH</i> | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL #0.128 (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

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